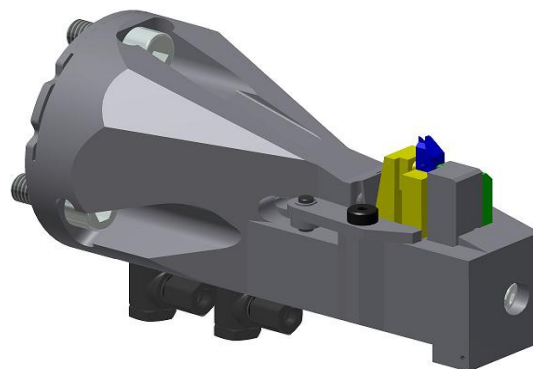
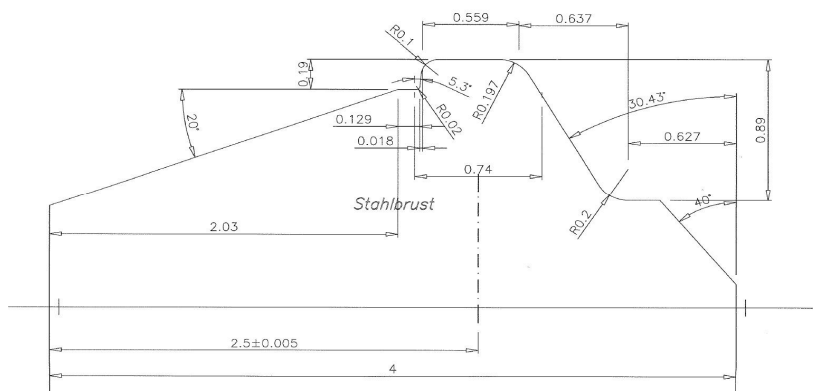










OnEdge single Thread Profile ID Ø9.75

A08-250

The below grinding cycle considers a setup for grinding with polished surface with finishing wheel D25 on a single edge of the triangular insert.



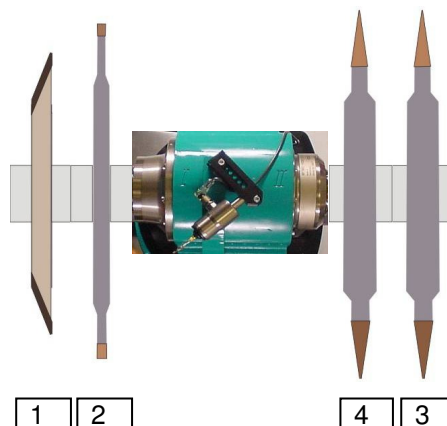
1. Cycletime for Production

Workpiece:	Triangle ID Ø9.75, B 4 mm			
Material	CARBIDE			
Operations				
Feed [mm/Min]	40	22	22	8
Power [kW]	1	2	1	1
Cutting speed [m/s]	20	20	20	22
Used wheels				
Grinding time [s]	26	34	31	69
Total cycle time	2 Min 39			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1V1 Ø250 D30
2	14A1 Ø300 D64
3	14EE1 Ø300 D25V20°
4	14EE1 Ø300 D46V20°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : SIRIUS HPM

Control: Fanuc 31i

Accessories: CTC

Responsible engineer: OP. 7.6.13

Coolant: Synthetic Oil, pressure 10 bar

Software: Quinto 5

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